

Date: Thursday, 6/15/2006 1:56:03 PM  
User: Kim Johnson

## Process Sheet

Split  
SB 06/09/28  
Split  
06/10/23

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : HI-STEP LEG ASSEMBLY  
Job Number : 27590 -3 Part Number : D3065041  
Estimate Number : 10385 Drawing Number : D3065 REV A2  
P.Q. Number : N/A Project Number : N/A  
This Issue : 6/15/2006 S.O. No. : N/A Drawing Revision : A2  
Prsht Rev. : NC Material : N/A  
First Issue : 6/15/2006 Type : SMALL /MED FAB Due Date : 7/2/2006 Qty: 60 Um: Each  
Previous Run : 26928  
Written By :  
Checked & Approved By :  
Comment : Est Rev: C 02.11.01 Incorporated D3066-1 IPP KJ/RF

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 27590A STEP SPACER



Comment: Sub-Component STEP SPACER

2.0 27590B STEP SPACER



Comment: Sub-Component STEP SPACER

3.0 27590C STEP LEG



Comment: Sub-Component STEP LEG

4.0 27590D STEP SPACER



Comment: Sub-Component STEP SPACER

5.0 D30651 Step Spacer



Comment: Qty.: 0.0000 Each(s)/Unit Total : 0.0000 Each(s)  
Step Spacer

Pick:

Qty Part Number Description Batch  
1 D3065-1 Spacer

B 28738 A 3 mx

B 27590A - 32 mx B 2652A - 4

6.0 D30653 Step Spacer



Comment: Qty.: 0.0000 Each(s)/Unit Total : 0.0000 Each(s)  
Step Spacer

Pick:

Qty Part Number Description Batch  
1 D3065-3 Spacer

B 27590 B

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HI-STEP LEG ASSEMBLY

Job Number: 27590

Part Number: D3065041

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

D30655

Step Leg



Comment: Qty.: 0.0000 Each(s)/Unit Total : 0.0000 Each(s)  
Step Leg

Pick:

Qty	Part Number	Description	Batch
2	D3065-5	Leg	B 27590 c

8.0

D30657

Step Spacer



Comment: Qty.: 0.0000 Each(s)/Unit Total : 0.0000 Each(s)  
Step Spacer

Pick:

Qty	Part Number	Description	Batch
1	D3065-7	Spacer	B 27590 D - 33 mx

B 26928 D - 6mx

9.0

MS20470AD44

Rivet, Universal Head



Comment: Qty.: 30.0000 Each(s)/Unit Total : 1800.0000 Each(s)  
Rivet, Universal Head

Pick:

Qty	Part Number	Description	Batch
30	MS20470AD4-4	Rivet	m100993

mf. 06-11-20

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3065 and Identify as D3065-041

mf.

06-11-20

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 06/11/20

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

GA

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: RP Date: 06/12/14

NOTE: Date & initial all entries QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Thursday, 6/15/2006 1:56:03 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HI-STEP LEG ASSEMBLY

Job Number: 27590

Part Number: D3065041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL  
Inspection Level 21

AD 06/12/1

Job Completion



U 06-12-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



**DART**

DESIGN	<i>CP</i>	DRAWN BY	<i>CP</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>#</i>	APPROVED	<i>#</i>	DRAWING NO. <b>D3065</b>	REV. A SHEET 1 OF 5
DATE	<b>02.09.11</b>			TITLE <b>STEP LEG ASSEMBLY</b>	SCALE 1:2
A	02.09.11			NEW ISSUE	
A1	03.07.13 <i>CP</i>			ADD SLOTS TO D3065-5	
A2	03.02.27 <i>CP</i>			0.531 WAS 0.410	

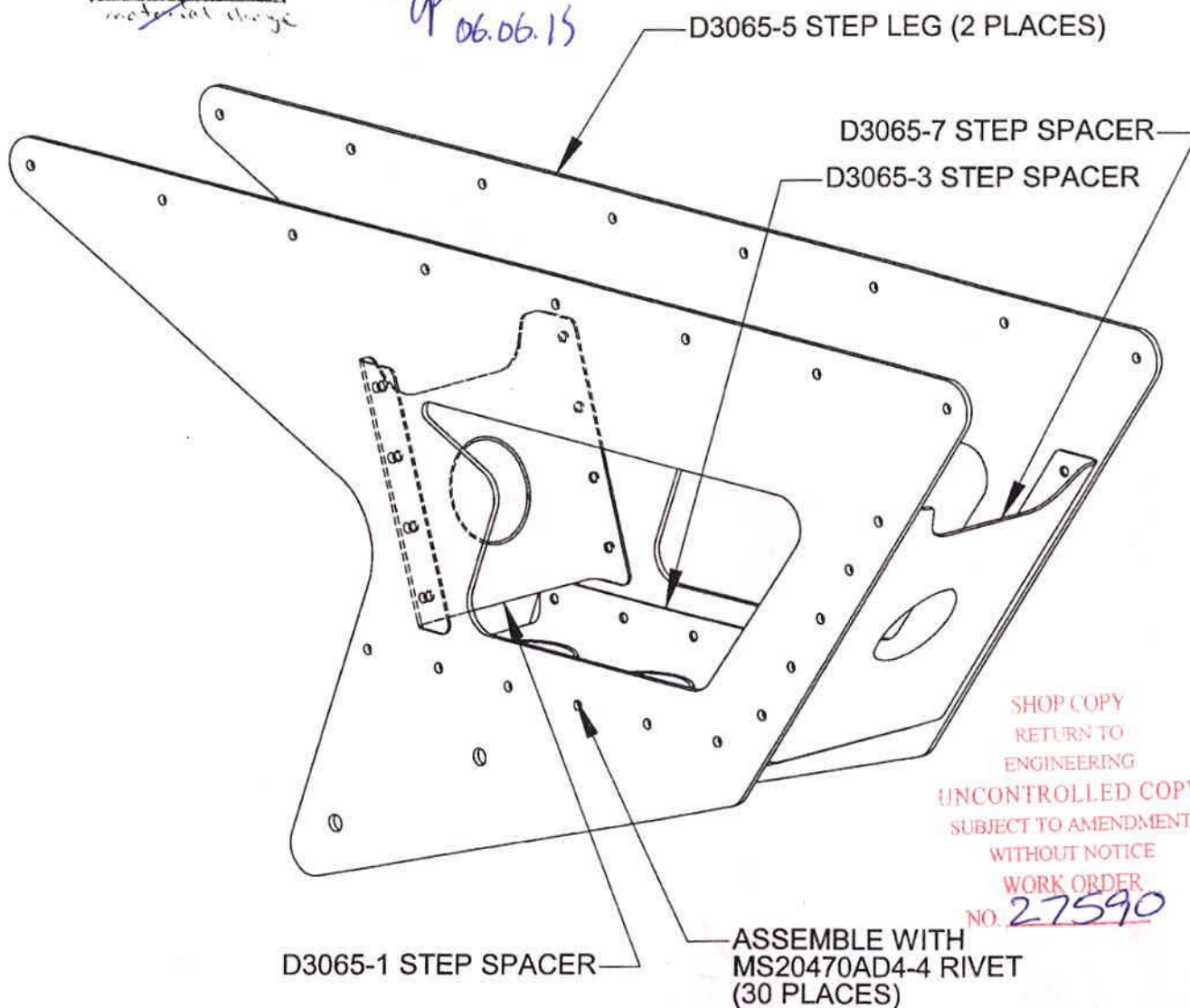
RELEASED  
02.01.20 *#*

**UNDER REVIEW**

06.06.02 *CB*

material change

*OK CP*  
06.06.15



## **D3065-041 STEP LEG ASSEMBLY**

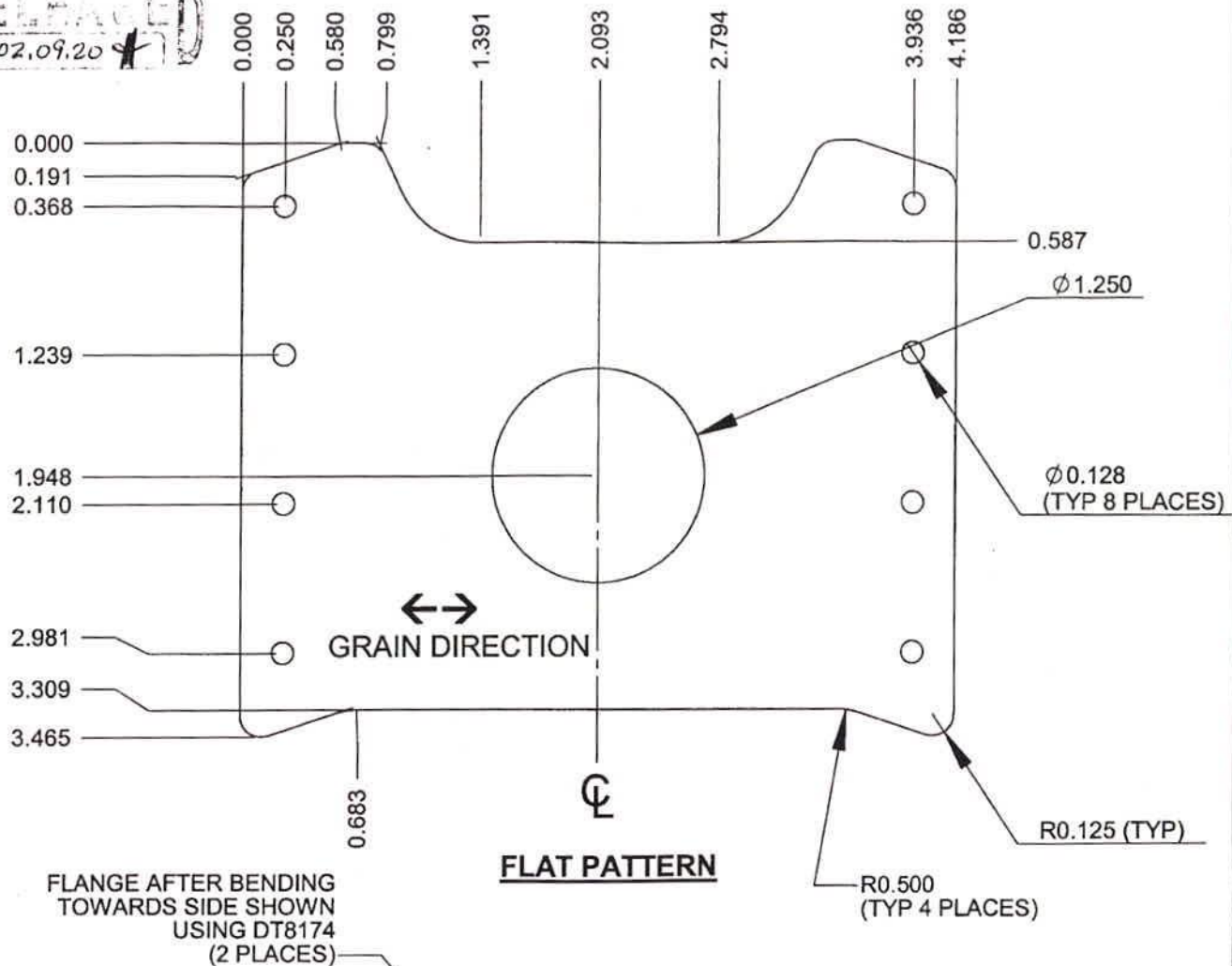
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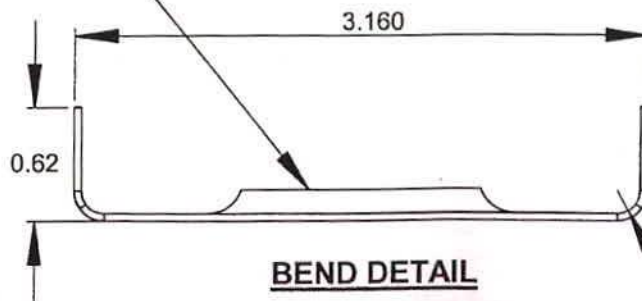
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CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. <b>D3065</b>	REV. A SHEET 2 OF 5
DATE <b>02.09.11</b>		TITLE <b>STEP LEG ASSEMBLY</b>	SCALE 1:1

RELEASED  
02.09.20

**UNDER REVIEW**

06.06.08 CB  
material change

OK *CP* 06.06.15



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WITHOUT NOTICE  
WORK ORDER  
NO. 27590  
R0.125 (TYP)

**D3065-1 STEP SPACER**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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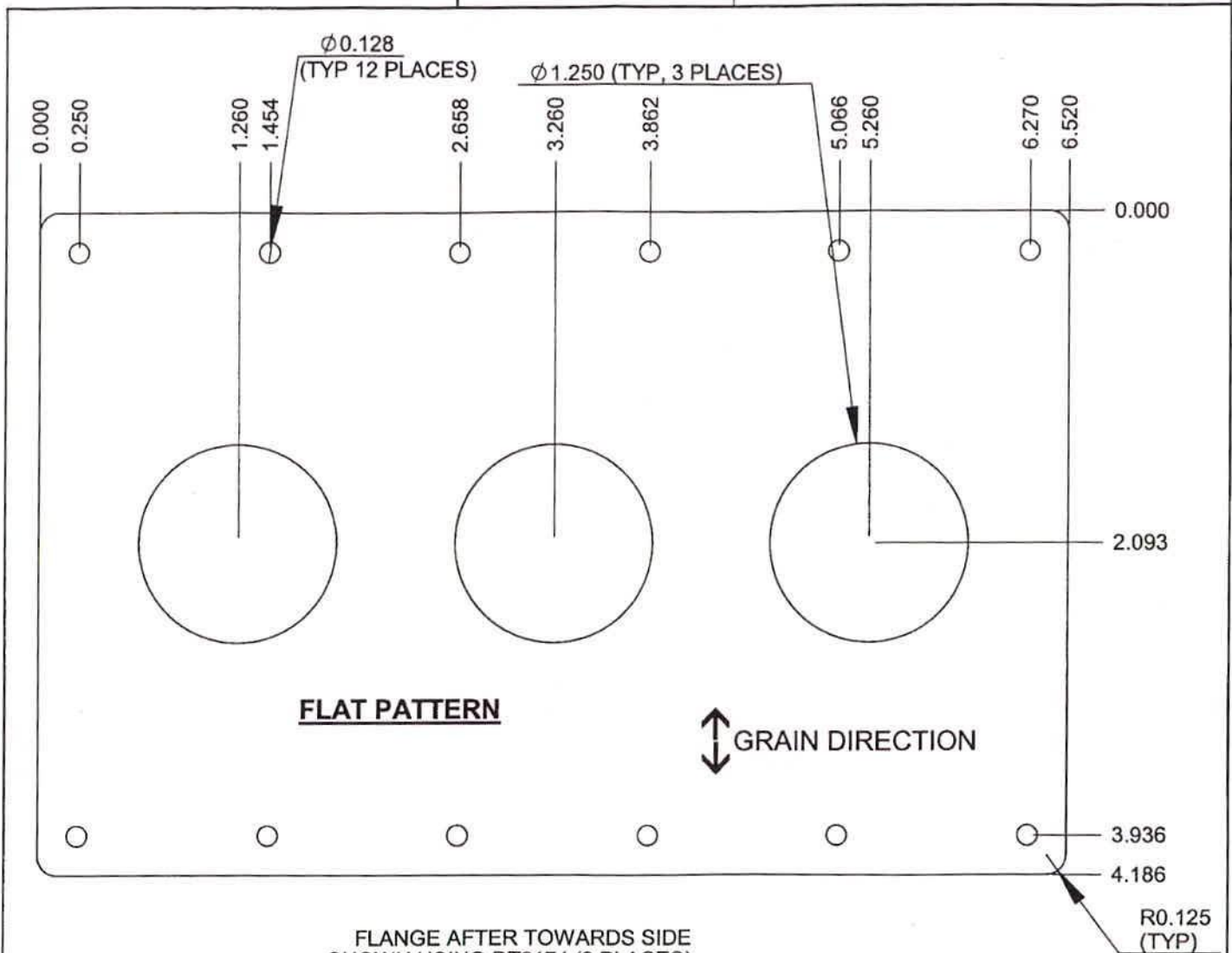


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02.09.20

**DART**



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DATE <b>02.09.11</b>		TITLE <b>STEP LEG ASSEMBLY</b>	SCALE 1:1

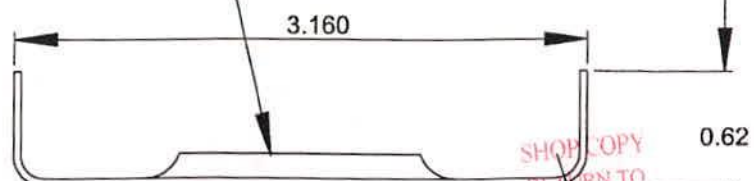


UNDER REVIEW

06.06.02 CD

material change

*OK*  
06.06.15



**D3065-3 STEP SPACER**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4)  
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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NO. **27590**

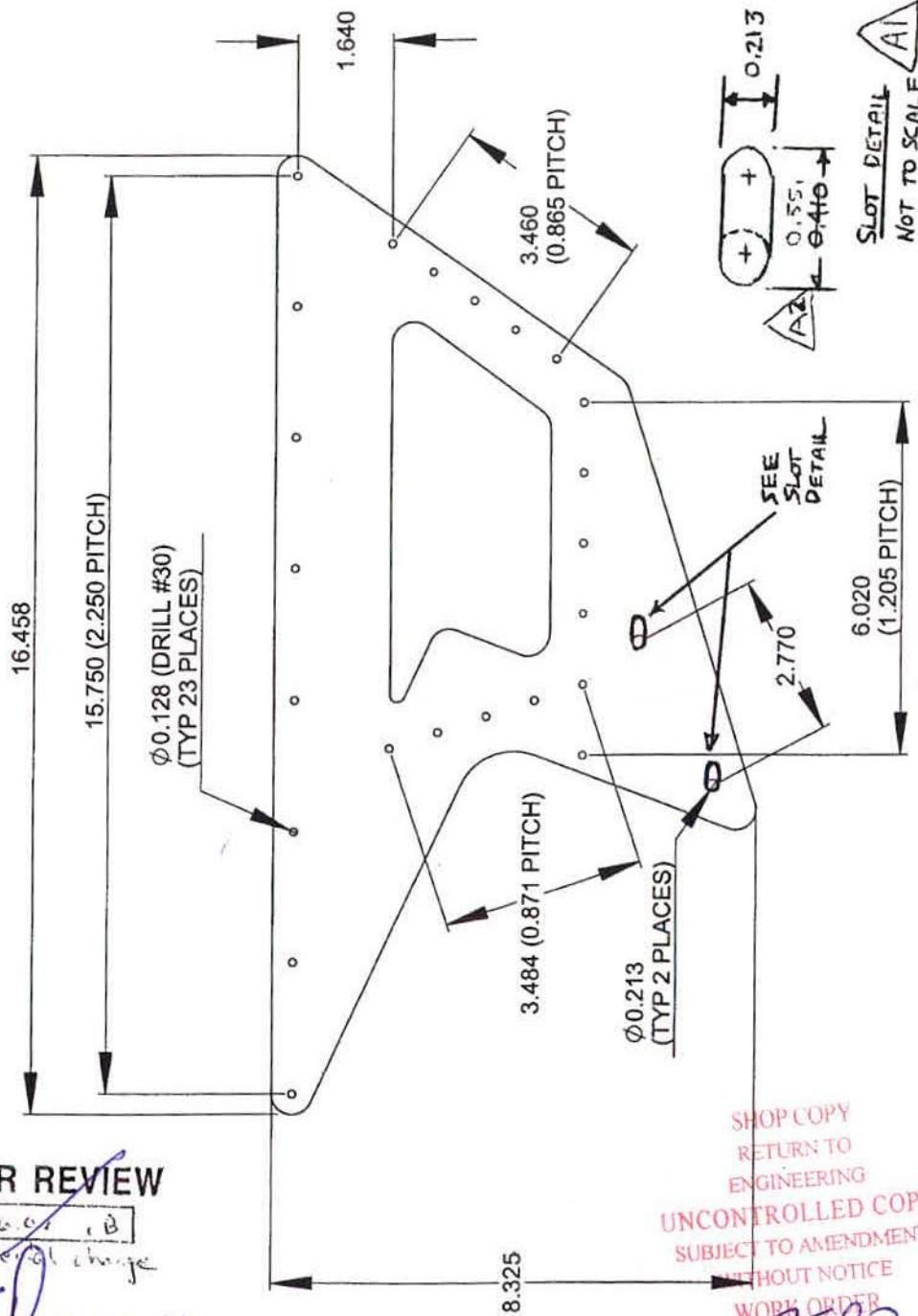
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CHECKED H	APPROVED H	DRAWING NO. D3065	REV. A SHEET 4 OF 5
DATE 02.09.11	TITLE STEP LEG ASSEMBLY		SCALE 1:3

RELEASED  
02.09.20 #

**UNDER REVIEW**

06.06.15

material change

OK CP 06.06.15

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NO. 27590

**D3065-5 STEP LEG**

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 5052-H32 (QQ-A-250/8) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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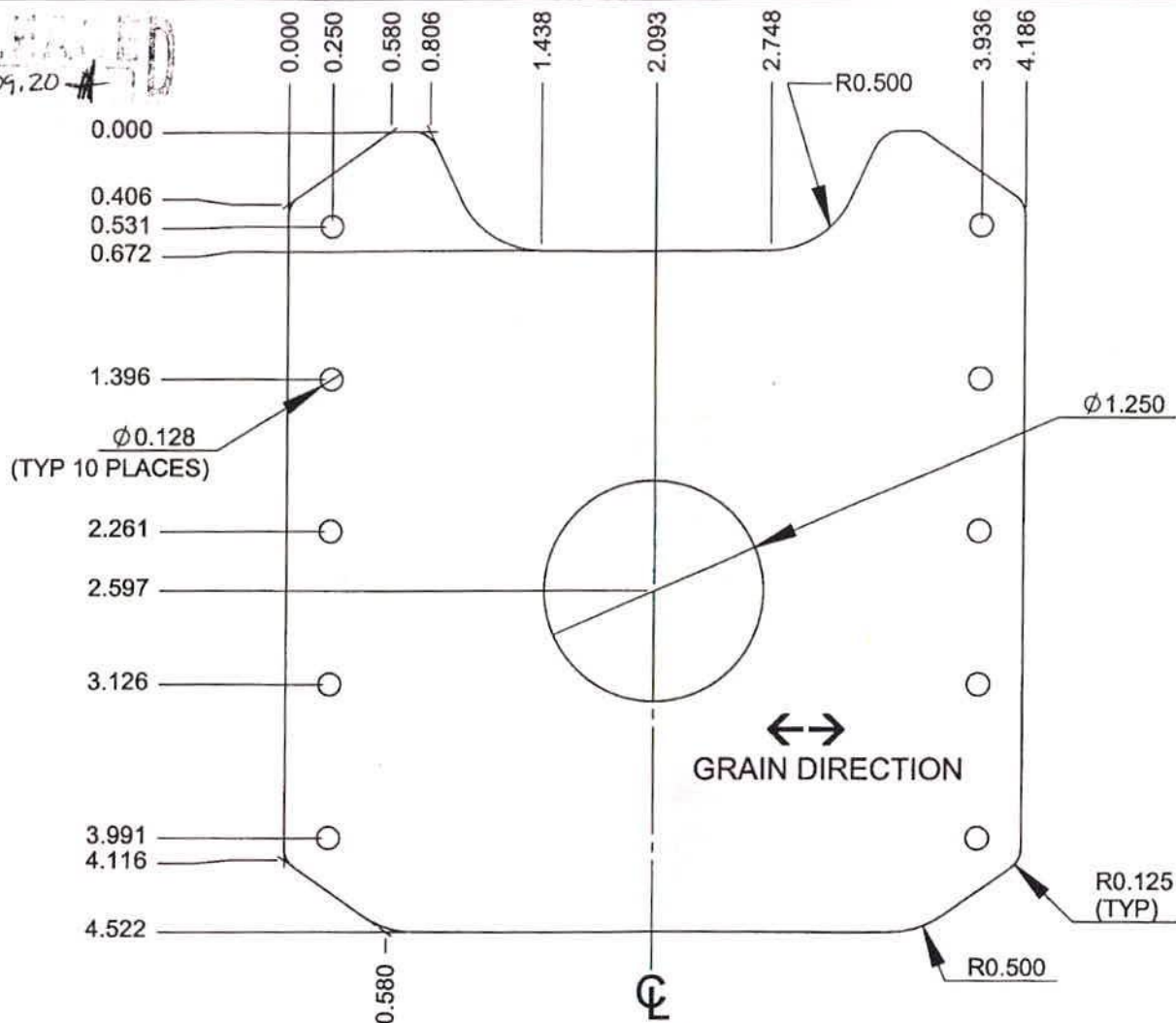
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DATE 02.09.11		TITLE STEP LEG ASSEMBLY SCALE 1:1	

RECEIVED  
02.09.20



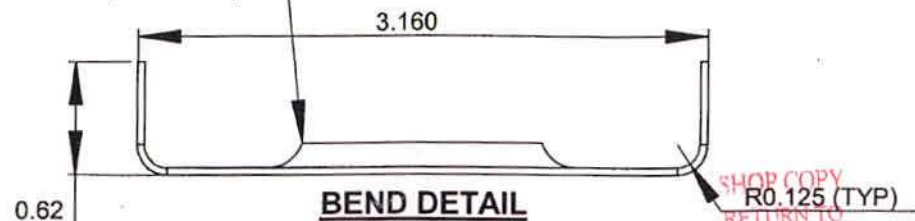
FLANGE AFTER BENDING TOWARDS  
SIDE SHOWN USING DT8174 (2 PLACES)

**FLAT PATTERN**

UNDER REVIEW

*no change*  
*material change*

*OK CP 06.06.15*



**BEND DETAIL**

**D3065-7 STEP SPACER**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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